

Wednesday, December 07, 2016 11:09:05 A

Page 1

DAS
21
9-88

DAS
6
9-89

7

FF

3

DAS
38
9-89

~~MAR 16 2017~~

7x

DAS
27
9-89
MAR 17 2017

Work Order ID 154276

Wednesday, December 07, 2016 11:09:05 A

154276

Page 2

Item ID: 644.4101 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pivot Step Assembly
Start Date: 12/23/2016 Start Qty: 7.00 ***7*** Cust Item ID:
Required Date: 12/23/2016 Req'd Qty: 7.00 ***7*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
140									
QC	Memo	0.12							
Quality Control									

**DAS
21
9-89**

MAR 17 2017

Picklist Print

Wednesday, December 07, 2016 11:09:08 AM

Page 1

Work Order ID: 154276

154276

Parent Item: 644.4101

644 4101

Parent Item Name: Pivot Step Assembly

Start Date: 12/23/2016

Required Date: 12/23/2016

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP REV:A 16.12.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																		
644.4103 *644 4103* Aft Bracket Assembly		Purchased	No				Each	0.0000	**	7 154278		AS 3 9-89 FEB 07 2017																			
644.4110 *644 4110* Bracket (Large) Aft		Purchased	No				Each	0.0000	**	7 154287		DAS 6 9-89 FEB 02 2017																			
644.4112 *644 4112* Spacer		Purchased	No				Each	0.0000	**	14 154240		DAS 6 9-89 FEB 02 2017																			
644.4113 *644 4113* Spacer, Stop		Purchased	No				Each	0.0000	**	14 154282		DAS 6 9-89 FEB 02 2017																			
644.4118 *644 4118* Washer, Nylon		Purchased	No				Each	0.0000	**	14 154271	(14)																				
NAS1149C0463R *NAS1149C0463R* Washer		Purchased	No				Each	395.0000	**	28		DAS 6 9-89 FEB 02 2017																			
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>FP001</td><td>40</td><td></td></tr><tr><td>m127306</td><td>40</td><td></td></tr><tr><td>ST266</td><td>355</td><td></td></tr><tr><td>m134167</td><td>155</td><td></td></tr><tr><td>m136263</td><td>200</td><td></td></tr></table>														Location	Loc Qty	Loc Code	FP001	40		m127306	40		ST266	355		m134167	155		m136263	200	
Location	Loc Qty	Loc Code																													
FP001	40																														
m127306	40																														
ST266	355																														
m134167	155																														
m136263	200																														
AN4-45 *AN4-45* BOLT		Purchased	No				Each	0.0000	**	7 136349		DAS 6 9-89 FEB 02 2017																			

Picklist Print

Wednesday, December 07, 2016 11:09:09 AM

Page 2

Work Order ID: 154276

154276

Parent Item: 644.4101

644 4101

Parent Item Name: Pivot Step Assembly

Start Date: 12/23/2016

Required Date: 12/23/2016

Start Qty: 7.00

Required Qty: 7.00

AN4-47A Purchased No

Each 18.0000 7

AN4-47A

BOLT

**

DAS
6
9-89

FEB 02 2017

Location

Loc Qty

Loc Code

ST341

18

m134883

18

Each

31.0000

7

AN310-5

AN310-5

Nut

Purchased No

**

FEB 02 2017

Location

Loc Qty

Loc Code

ST331

31

m135672

31

Each

100.0000

14

MS21044N5

MS21044N5

NUT

Purchased No

**

FEB 02 2017

Location

Loc Qty

Loc Code

ST302

100

m129624

100

Each

5.0000

14

AN5-43A

AN5-43A

Bolt

Purchased No

**

FEB 02 2017

Location

Loc Qty

Loc Code

ST336

5

M134508

5

Each

331.0000

28

NAS1149C0563R

NAS1149C0563R

Washer

Purchased No

**

FEB 02 2017

Location

Loc Qty

Loc Code

ST265

331

m131697

331

Wednesday, December 07, 2016 11:09:09 AM

Shop Packet Print

Page 2

Picklist Print

Wednesday, December 07, 2016 11:09:09 AM

Page 3

Work Order ID: 154276

154276

Parent Item: 644.4101

644 4101

Parent Item Name: Pivot Step Assembly

Start Date: 12/23/2016

Required Date: 12/23/2016

Start Qty: 7.00

Required Qty: 7.00

644.4120

Purchased

No

Each

0.0000

7

644 4120

Spacer, Crosstube

MS24665-132

Purchased

No

Each

0.0000

7

MS24665-132

Cotter Pins

MS21044N4

Purchased

No

Each

31.0000

7

MS21044N4

Nut, Self-Locking

Location

Loc Qty

Loc Code

ST302

31

m134676

31

DAS 6 9-89
154272
FEB 02 2017

DAS 6 9-89
136349
FEB 02 2017

DAS 6 9-89
136648
FEB 02 2017

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04489

SHEET 1 OF 1

DWG NO. 644,4100

REV: F

PREPARED BY:

J. BECKER

DATE: 04/08/14

EFFECT ON DWG
☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION
A-ADD
R-REVISE

CODES (C)
C-CREATE
D-DELETE

REASON: UPDATE NOTE 4, FINISH SPECIFICATION.

NOTES

1. IDENTIFY ALL PARTS IN ACCORDANCE WITH MPP-120
2. MATERIAL: 2024-T3 ALUMINUM
3. MATERIAL: 6061-T6 ALUMINUM
4. FINISH IAW MPP-172 SECTION 2.1, SECTION 3.1, SECTION 4.1, SECTION 5.2.
5. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 1/4" GASKET PUNCH
6. MATERIAL: MDS-FILLED NYLON 6/6 SHEET, CUT OD CIRCLE USING 2" GASKET PUNCH, CUT ID HOLE USING 5/16" GASKET PUNCH
7. DIMENSION VALUE HAS FINISH COATING OF 6-10 MIL (.006-.010) TAKEN INTO CONSIDERATION
8. ADD ADDITIONAL WASHER UNDERNEATH CASTLE NUTS IF NECESSARY.
9. FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2, COLOR BLACK.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 154276 M5
16-12-07

SHEET 1, NOTES IS:

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUC ☐ ICA ☐ BOM

CHANGE CATEGORY
☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED
☐ YES ☒ NO

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

04286

SHEET 1 OF 1

DWG NO. 644.4100

REV: F

PREPARED BY J. SOTO

DATE: 12/04/2013

EFFECT ON DWG

☐ INC. ☒ UNINC.

DWG TITLE: PIVOT STEP ASSY

APPROVED BY:

ENGR *[Signature]*

MFG

[Signature]

QC

[Signature]

EFF.

NEXT ORDER

TRANSACTION CODES (TC):

A-ADD
R-REVISE

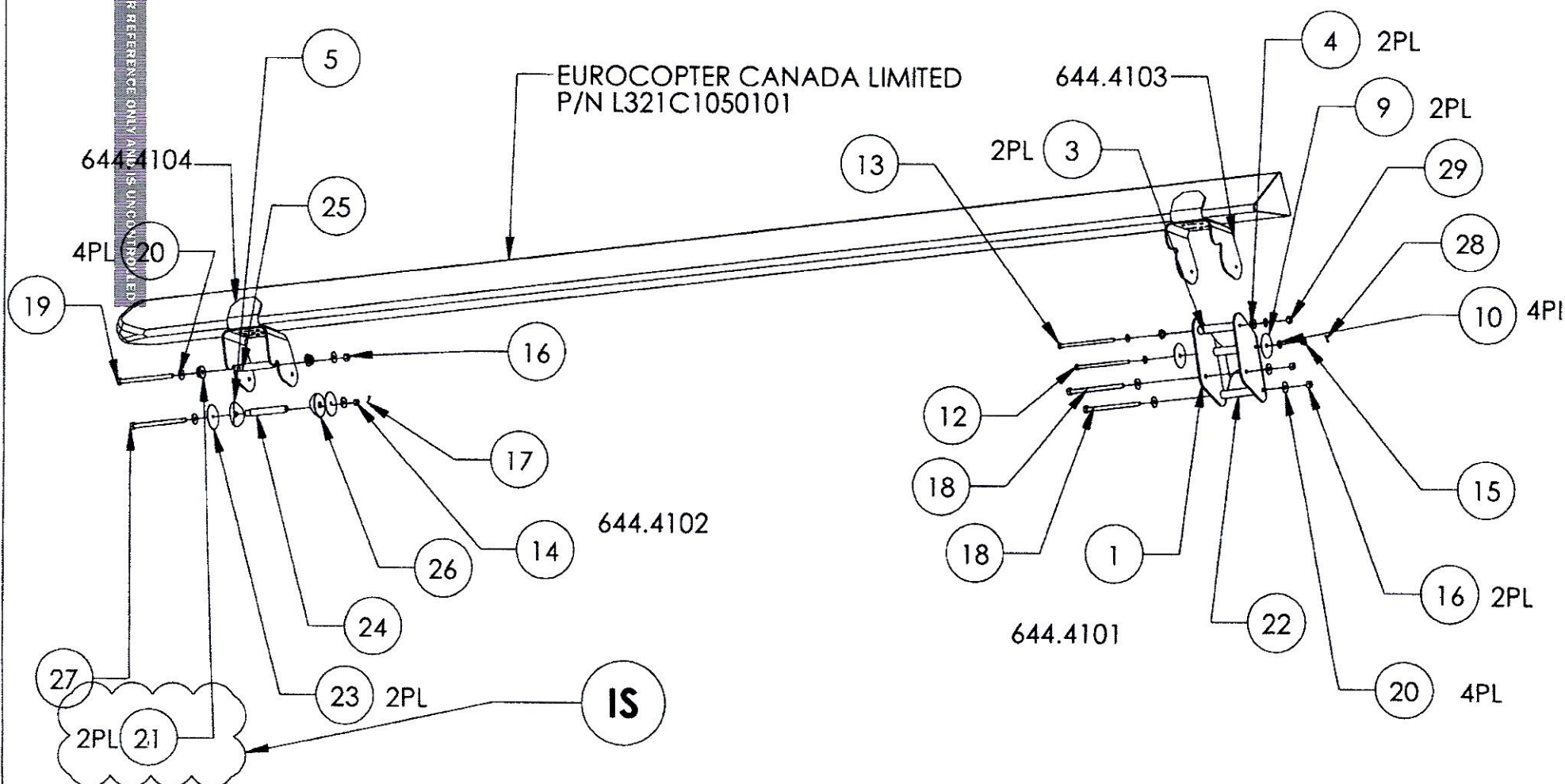
C-CREATE
D-DELETE

REASON: REVISED F/N CALL OUT FROM 22 TO 21

ECR:

13-151

SHEET 1, ZONE D1 IS:



DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

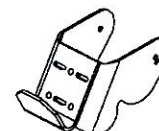
DER REVIEW REQUIRED

☐ YES ☒ NO

NOTES:

-
- 644.4102

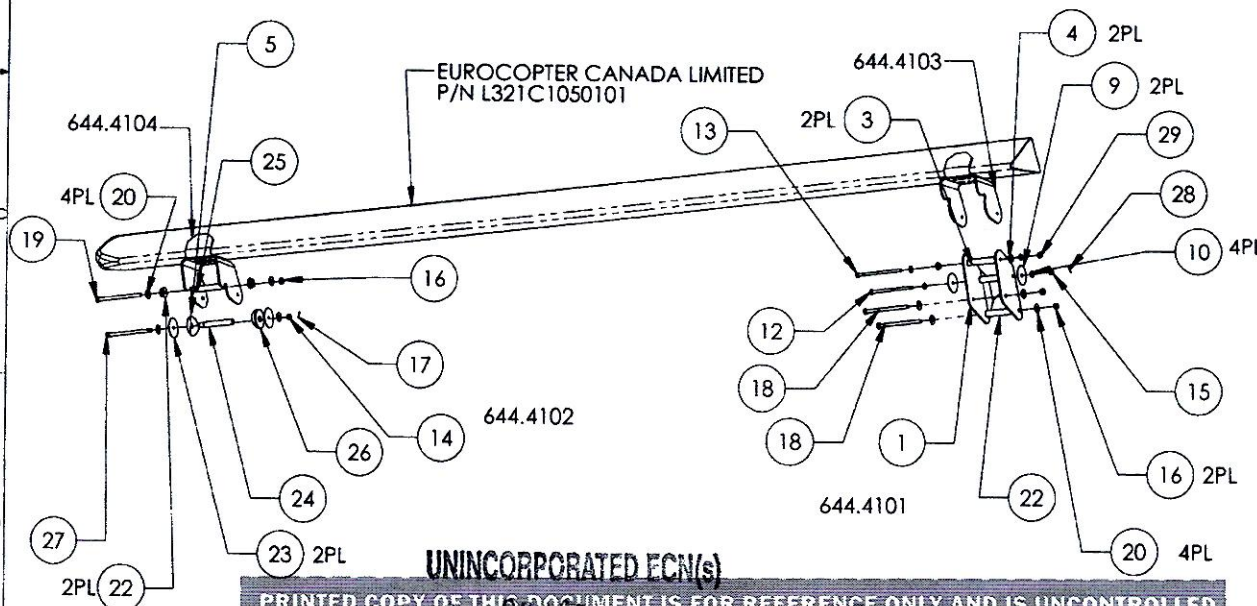
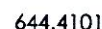
644.4102



644.4103



644.4104



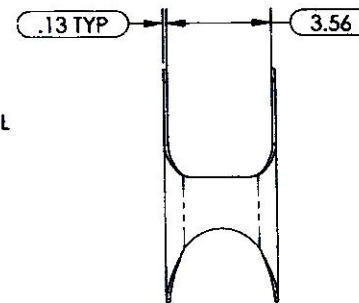
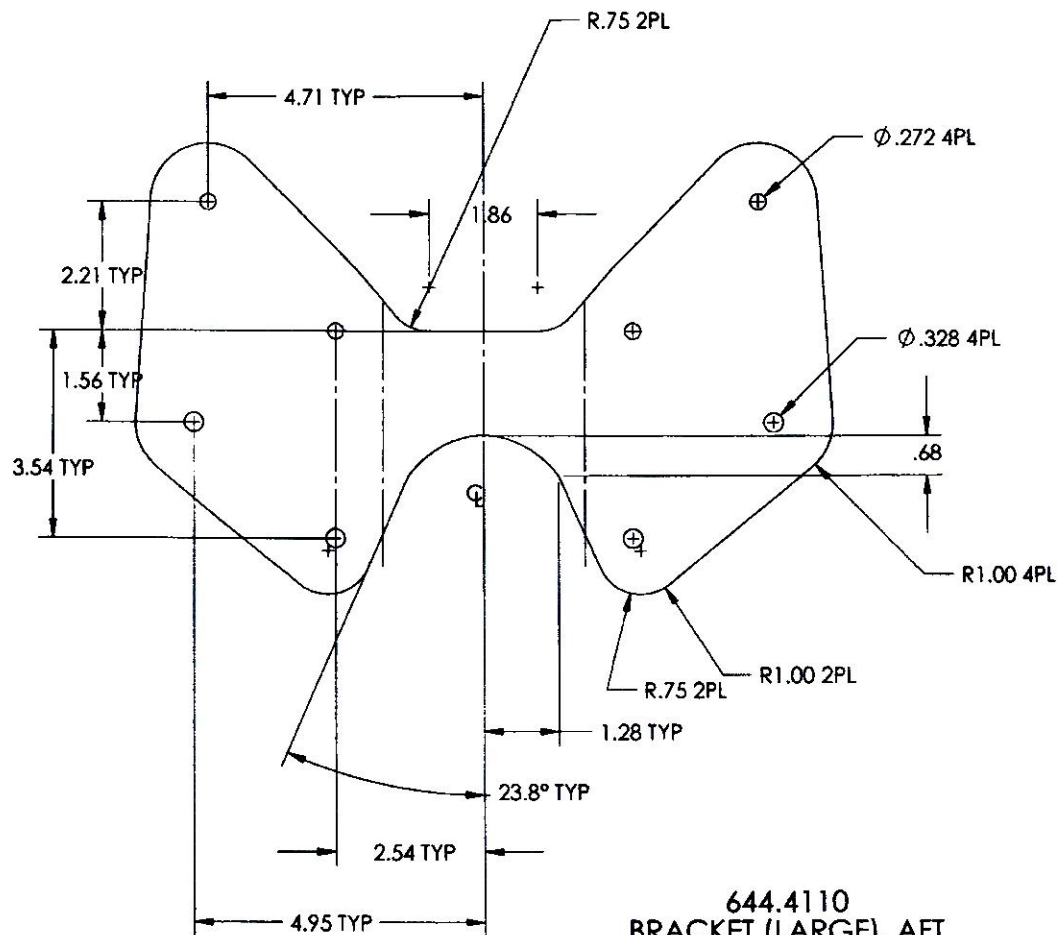
UNINCORPORATED ECN(s)

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REVIEWS			
REV.	DESCRIPTION	DATE	APPROVED
A	INCORPORATED ECH 01310, 01322, 01332, & 01357	11-22-05	S. JOSEPH
B	INCORPORATED ECH 01372, 01418, 01376, & 01434	05-21-07	P. BRAVO
C	INCORPORATED ECH 01408, 02536, 03022	12-14-10	P. BRAVO
D	INCORPORATED ECH 03111, 03113, 03208, & 03740	12-10-12	P. BRAVO
E	INCORPORATED ECH 02941	06-16-13	P. BRAVO
F	INCORPORATED ECH 80048	2-26-14	F. BRAVO

[illegible]

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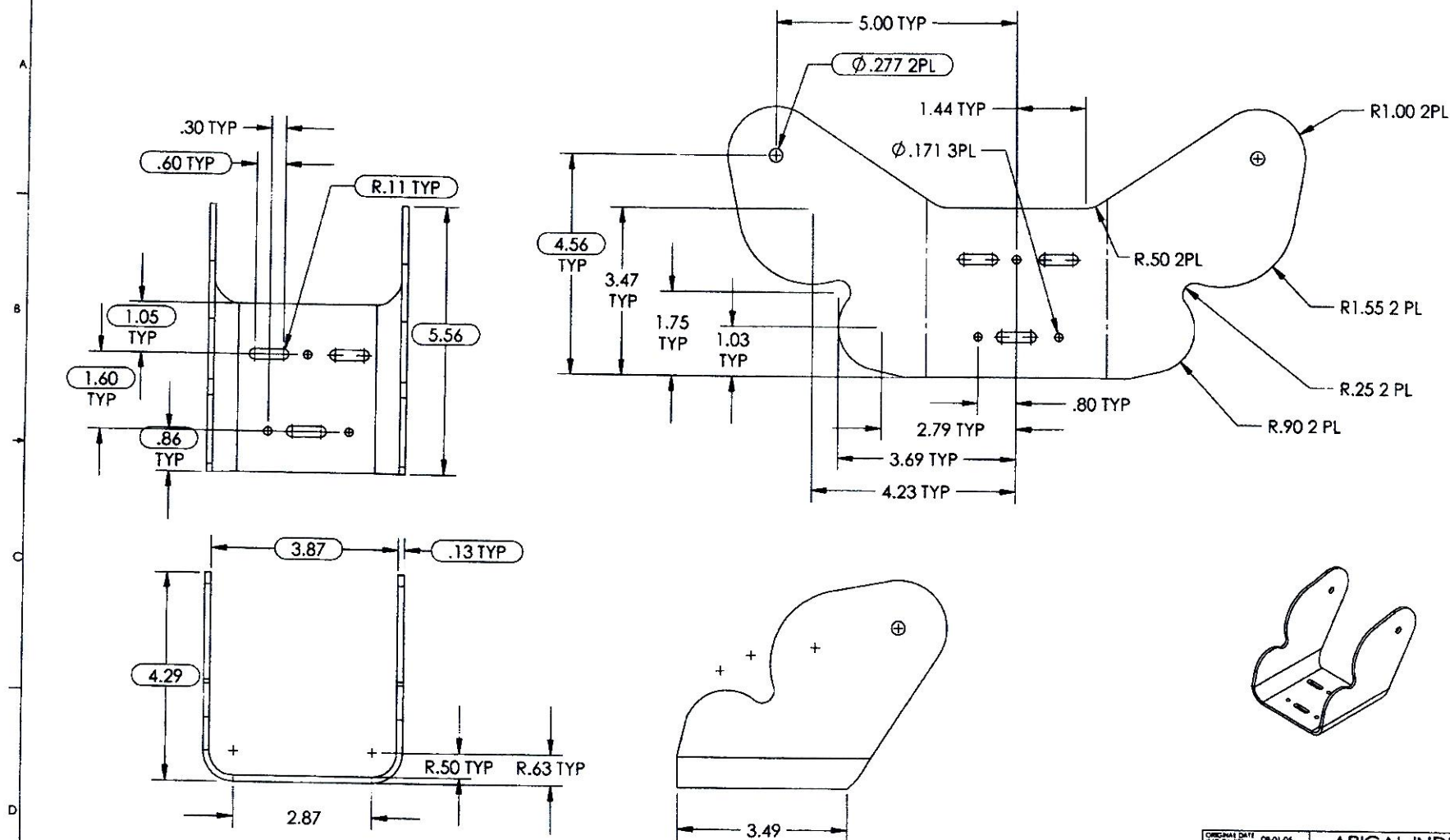


644.4110
BRACKET (LARGE), AFT

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ORIGINAL DATE 08-01-05	APICAL INDUSTRIES
DRAWN BY S. JOSEPH	2608 TEMPLE HEIGHTS DR.
CHECKED BY S. JOSEPH	OCEANSIDE, CA. 92056-3512 (760)724-5300
DATE 08-24-05	PIVOT STEP ASSY
CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.005 ANGLES ±.5°	SHEET 2 OF 16
SCALE NONE	

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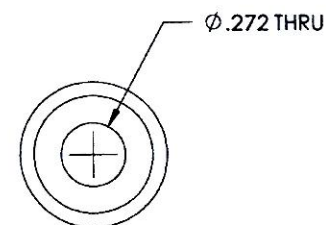
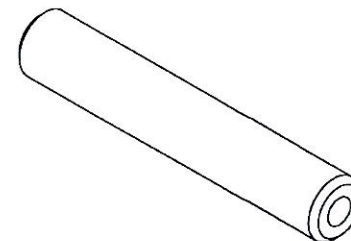
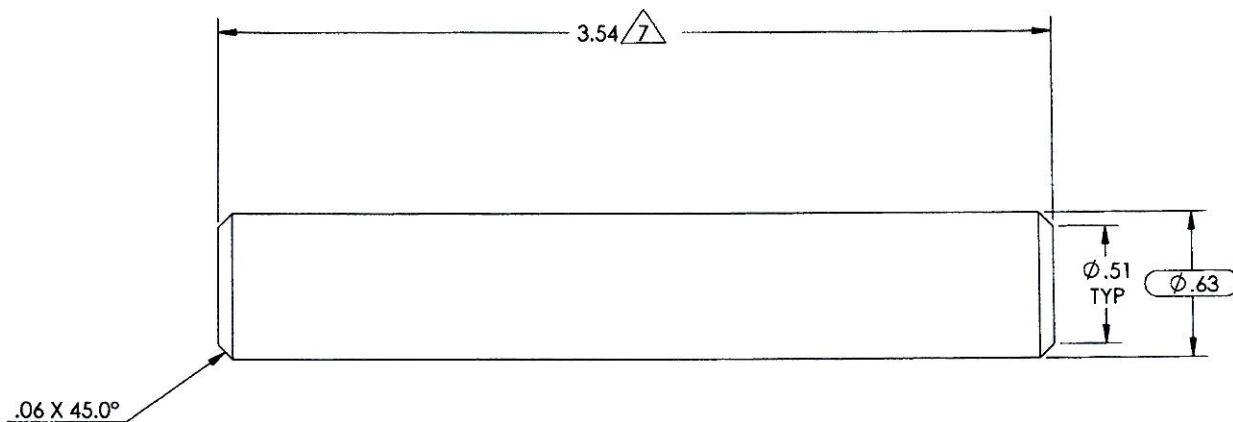


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644.4111
BRACKET, AFT PIVOT

ORIGINAL DATE 08-01-05	APICAL INDUSTRIES
DRAWN BY D. PARSON	2608 TEMPLE HEIGHTS DR.
CHECKED S. JOSEPH	OCEANSIDE, CA. 92056-3512 (760)724-5300
DRAWING APPROVAL S. JOSEPH 08-27-05	PIVOT STEP ASSY
CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .03 3 PLACE DECIMALS ± .010 ANGLES ± .5°	REV. NO. 644.4100
SCALE NONE	SHEET 3 OF 16

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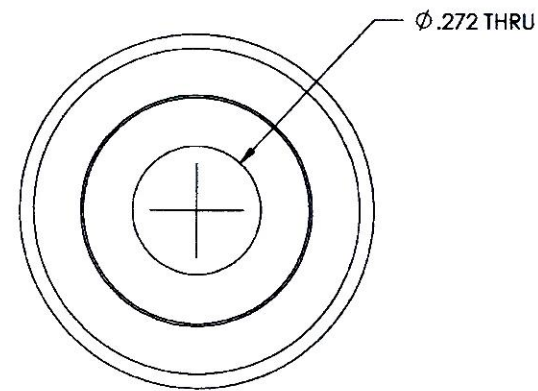
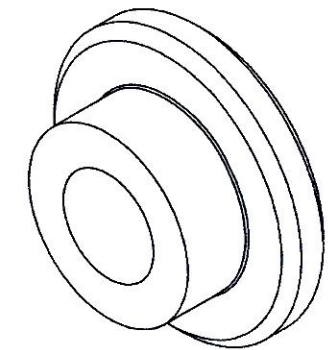
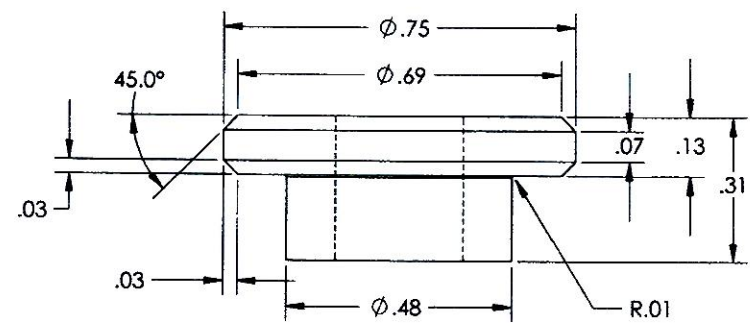


644.4112
SPACER

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ORIGINAL DATE 06-01-05		APICAL INDUSTRIES	
DRAWN BY	CHECKER		
DRAWN BY	S. JOSEPH	2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL	S. JOSEPH 08-29-05	OCEANSIDE, CA 92056-3512 (760)724-5300	
CONTRACT NO.		PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED		SERIAL	REV.
DIMENSIONS ARE IN INCHES		B	F
TOLERANCES ARE:		CAGE CODE	DWG NO
2 PLACE DECIMALS ±.03		07A26	644.4100
3 PLACE DECIMALS ±.010		SCALE	NONE
ANGLES ±.5°		SHEET	4 OF 16

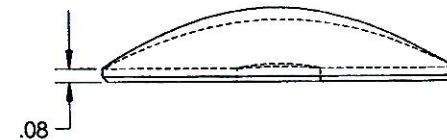
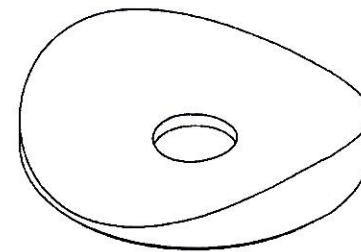
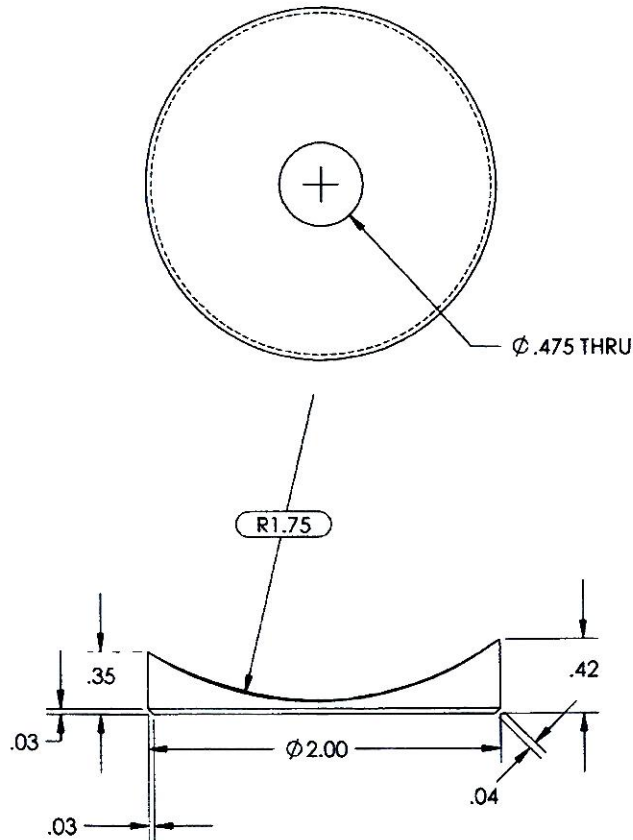
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ORIGINAL DATE 08-01-05		APICAL INDUSTRIES	
DRAWN BY J. PARROTT		2608 TEMPLE HEIGHTS DR.	
DRAWING APPROVAL S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760)724-5300	
CONTRACT NO.		PIVOT STEP ASSY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACES DECIMALS $\pm .03$ 3 PLACES DECIMALS $\pm .010$ ANGLES $\pm .5^\circ$		REV. B	REV. F
SCALE NONE		SHEET 5 OF 16	

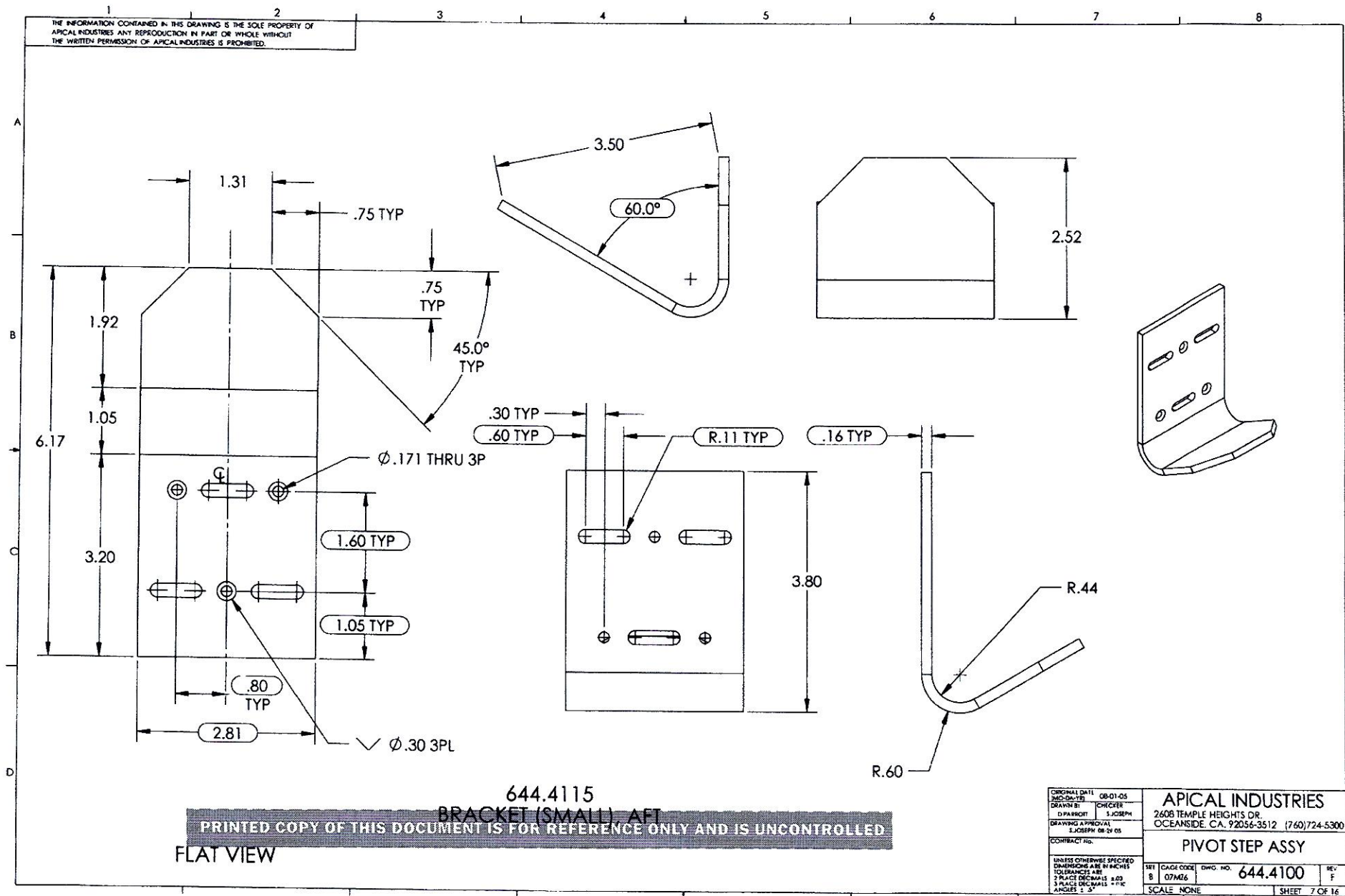
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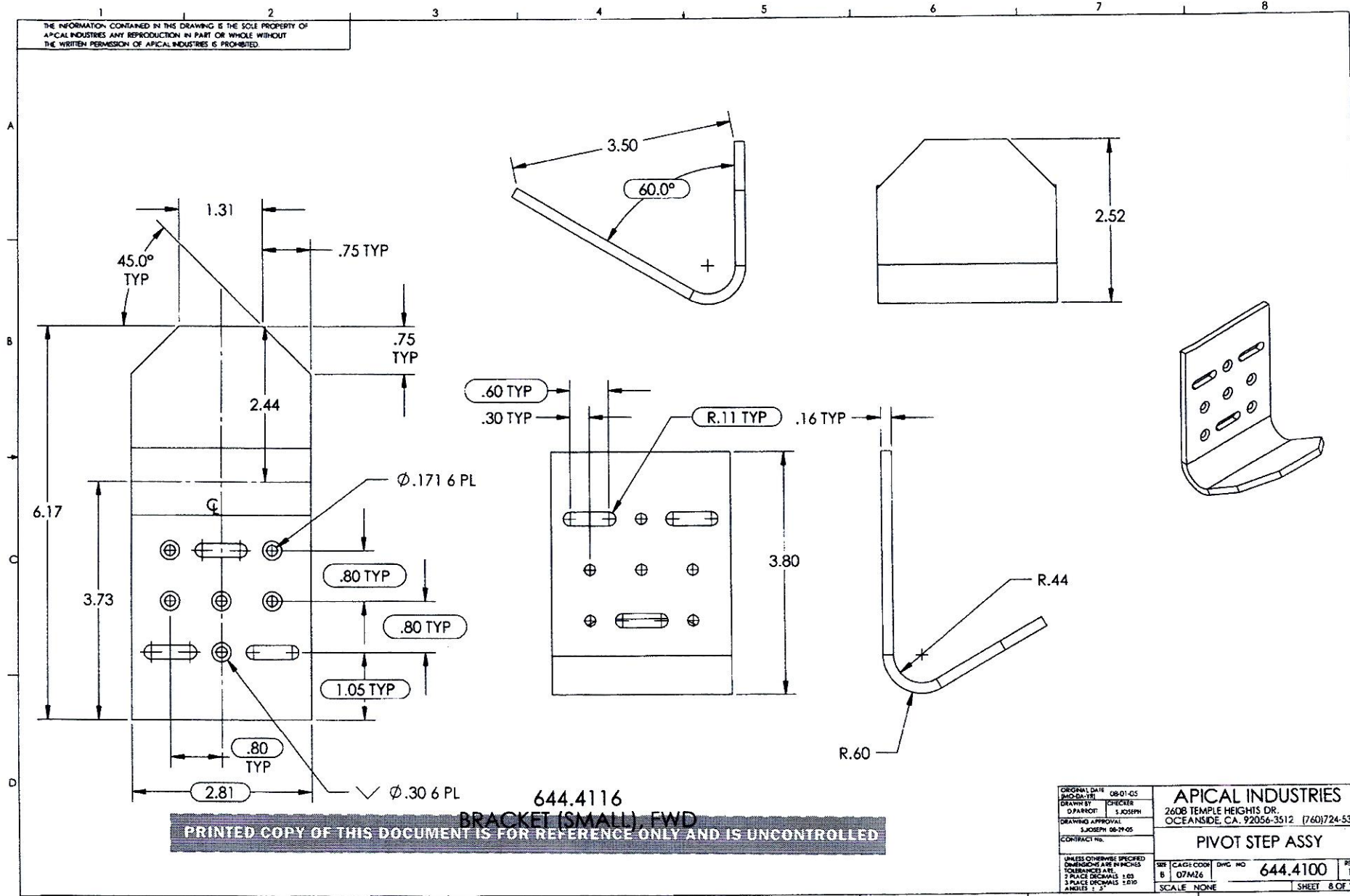
644.4114
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ORIGINAL DATE 08-01-05		APICAL INDUSTRIES	
DRAWN BY CHECKER		2608 TEMPLE HEIGHTS DR.	
D. PARROTT S. JOSEPH		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL		PIVOT STEP ASSY	
S. JOSEPH 08-29-05			
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES 1°		SHEET 6 OF 16	REV. F
SCALE NONE		DWG. NO. 644.4100	

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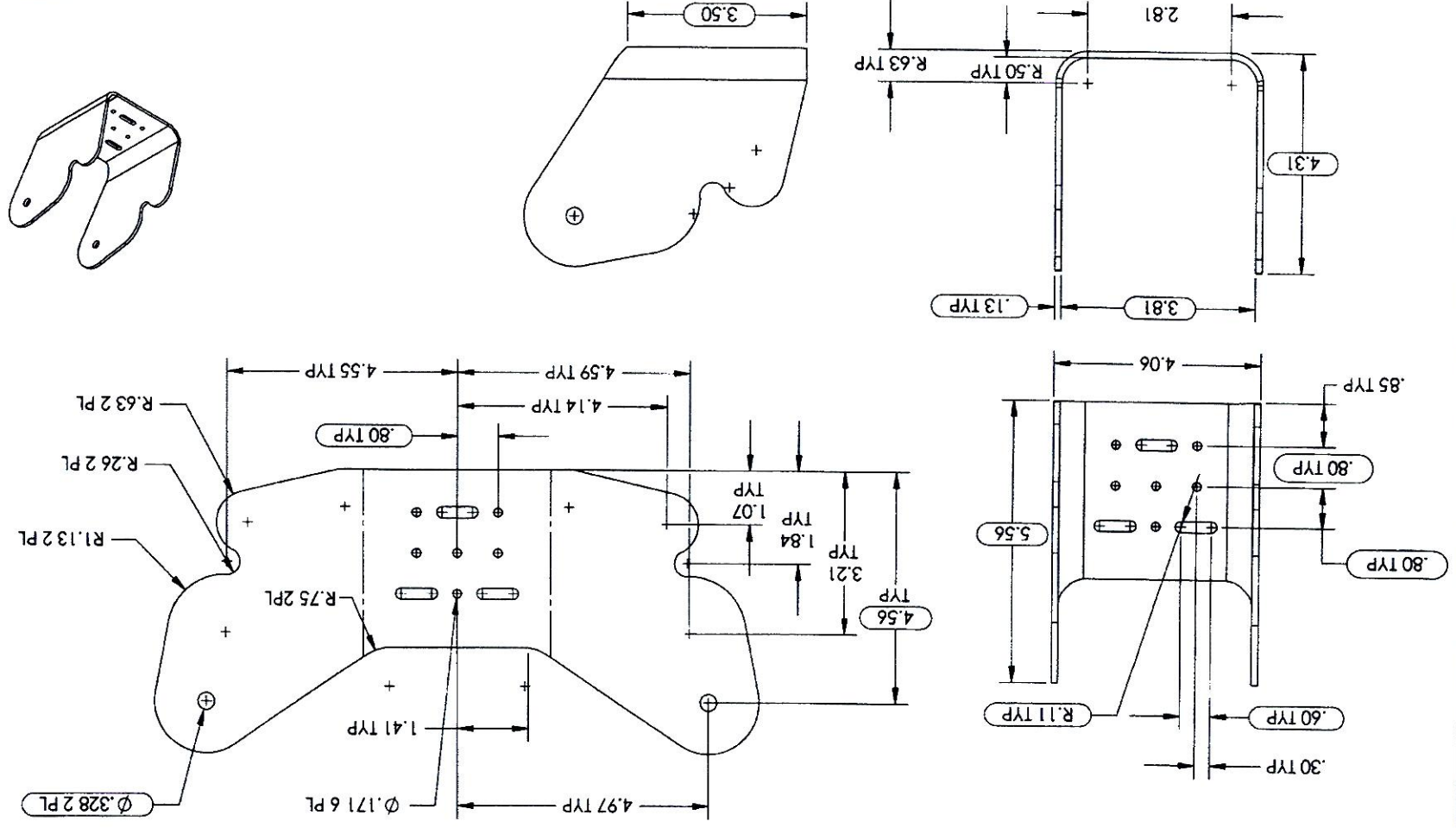


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BRACKET, FWD PIVOT



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ORIGINAL DATE	06-01-05
INDUSTRY	APICAL INDUSTRIES
DRAWING NO.	1.05874
SCALE	AS SHOWN
DESIGNED BY	1.05874
CHECKED BY	1.05874
APPROVED BY	1.05874
DATE	06-01-05
COMPANY	APICAL INDUSTRIES
ADDRESS	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-5300
PIVOT STEP ASSY	644.4100
REV	F
DATE	07/04/06
BY	B
SCALE	NONE
SHEET	9 OF 16

1 2 3 4 5 6 7 8

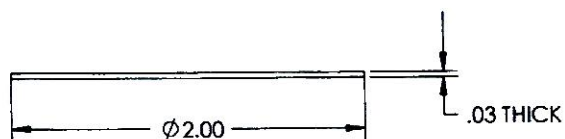
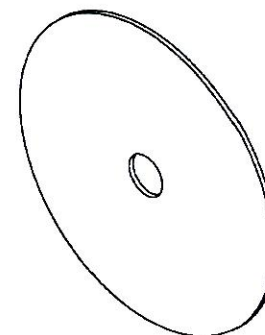
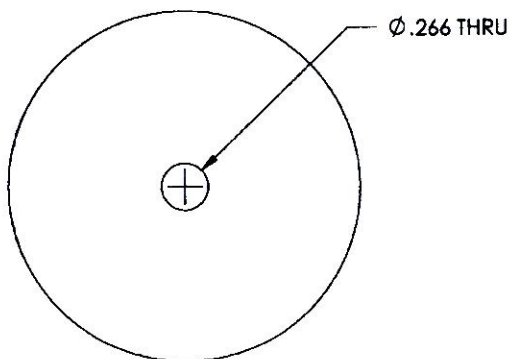
A

B

C

D

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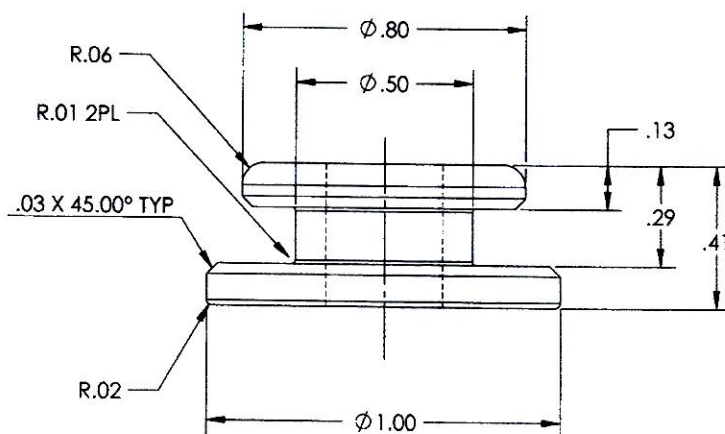
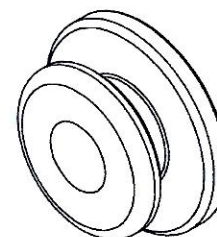
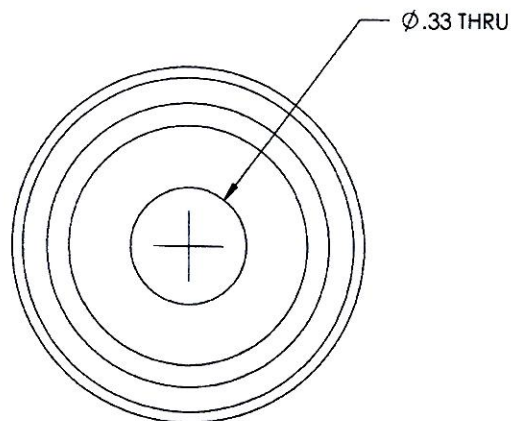


644.4118
WASHER, NYLON

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ORIGINAL DATE 08-01-05	APICAL INDUSTRIES	
DRAWN BY J. JOSEPH	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL J. JOSEPH 08-29-05	PIVOT STEP ASSY	
CONTRACT NO.	SIZE B	CAGE CODE 07M26
UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.5°	DWG. NO. 644.4100	REV. F
SCALE NONE		SHEET 10 OF 16

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644.4119
SPACER, FWD STOP

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ORIGINAL DATE: 08-01-05		APICAL INDUSTRIES	
DRAWN BY: J. JOSEPH		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: J. JOSEPH		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL: J. JOSEPH 08-24-05		PIVOT STEP ASSY	
CONTRACT NO.:		SCALE: NONE	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.02 3 PLACE DECIMALS ±.010 ANGLES ±.5°		REV. F	SHEET 11 OF 16

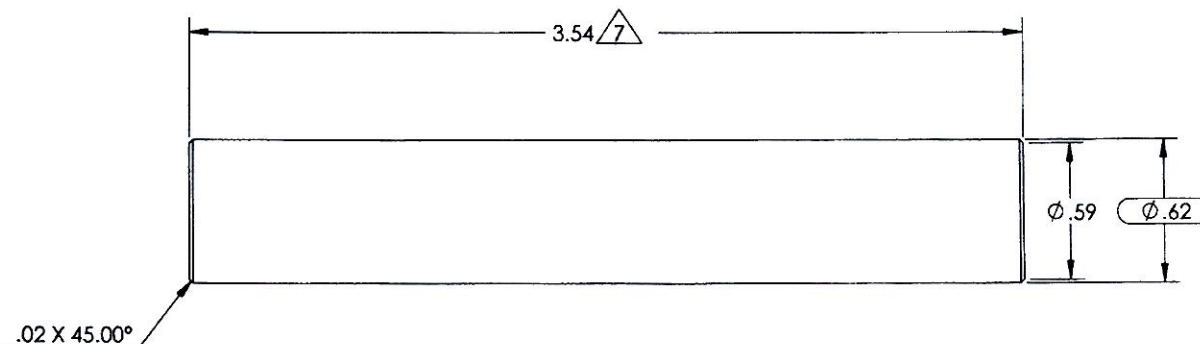
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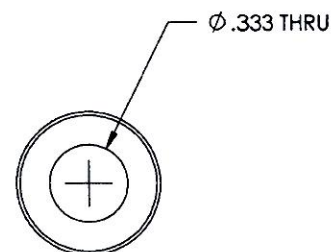
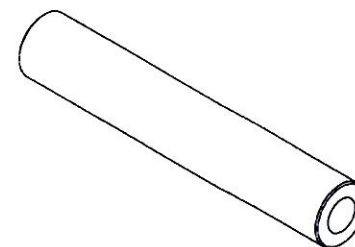
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C

D



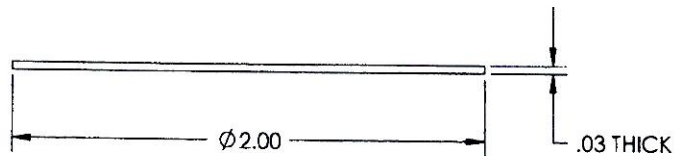
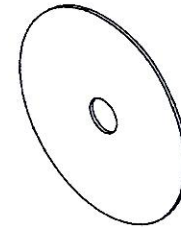
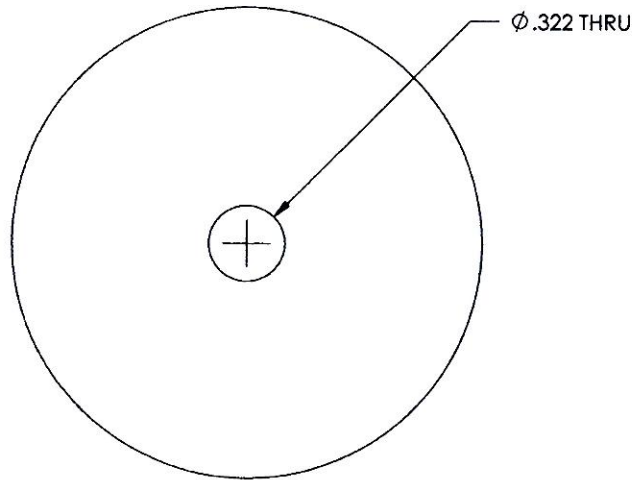
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SPACER, CROSS-TUBE



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DRAWING APPROVAL S. JOSEPH 06-29-05	SEE CAGE CODE B 07MZ6	DWG NO. 644.4100
CONTRACT NO.	SCALE NONE	REV. F
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .010 ANGLES ± .5°		SHEET 12 OF 16

1 2 3 4 5 6 7 8
A
B
C
D
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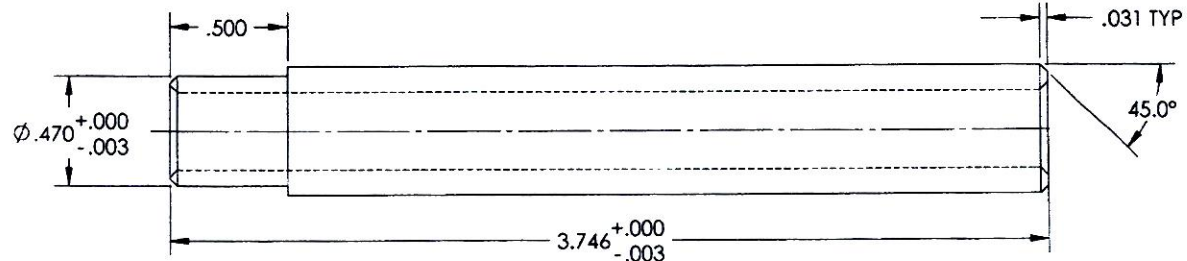
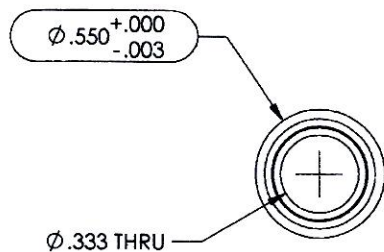
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		B 07M26	F
		SCALE NONE	SHEET 13 OF 16

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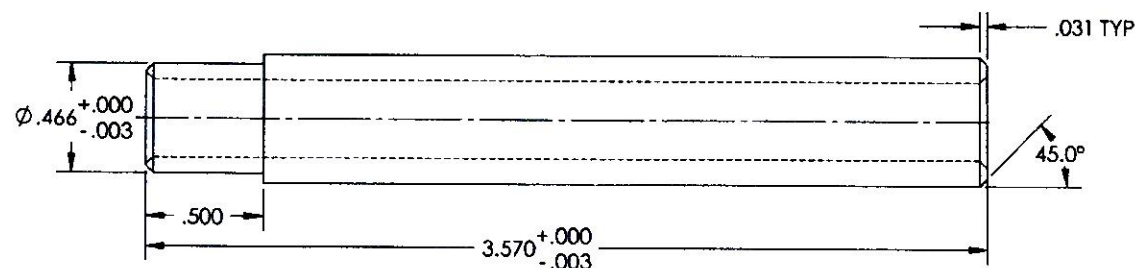
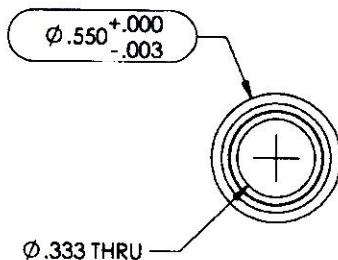


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DRAWING APPROVAL J. JOSEPH 06-29-05		PIVOT STEP ASSY	
CONTRACT NO.		REV	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.010 ANGLES ±.5°		SIZE CAGE CODE DWG. NO. 644.4100	REV
SCALE: NONE		SHEET 14 OF 16	

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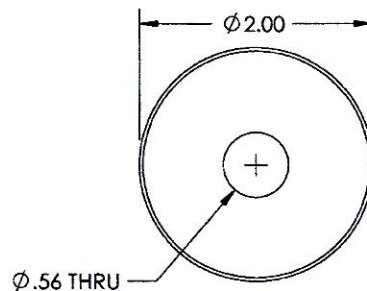
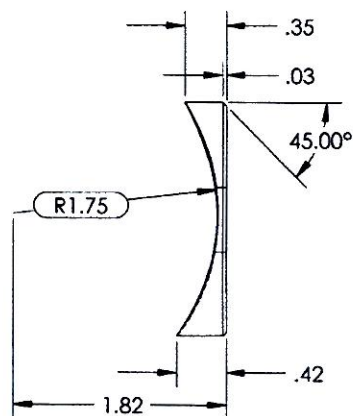


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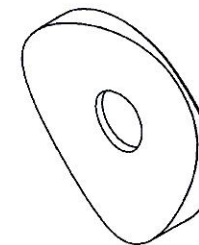
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DRAWN BY D. PALMISTO		2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL S. JOSEPH 08-29-05		PIVOT STEP ASSY	
CONTRACT NO.		REV. B	REV. F
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.003 ANGLES ±.5°		CAGE CODE 07M26	DWG. NO. 644.4100
SCALE: NONE		SHEET 15 OF 16	

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CHECKED BY J. COHEN		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		PIVOT STEP ASSY	
SHEET 1 OF 16		REV. F	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .003 3 PLACE DECIMALS .001 ANGLES 1.0°		SCALE: NONE	